












Date: Friday, 24/10/2008 12:55:39 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : PLUG
Job Number : 42936	
Estimate Number : 12322	
P.O. Number :	Part Number : D3492041
This Issue : 24/10/2008 S.O. No. :	Drawing Number : D3492 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : C
Previous Run : 42637	Material :
Written By :	Due Date : 31/10/2008 Qty: 160 Um: Each
Checked & Approved By : <u>JUL 08.10.24</u>	
Comment : : est rev A 06.03.03 New Issue EC Est Rev:B 06-08-28 As per Rev B JLM Est Rev:C 07-12-06 Rev C dwg DD verified by:EC	
Additional Product	
Job Number: 	
Seq. #:	Machine Or Operation:
Description :	
1.0	M6061T6R0625 6061-T6 Round Bar .625"
	 (161)
Comment: Qty.: 0.0656 f(s)/Unit Total : 6.5625 f(s) 6061-T6 Round Bar .625" (M6061T6R0625) Batch: <u>M109733</u> <u>mv 08/10/30</u>	
2.0	HARDINGE HARDINGE CNC LATHE SMALL
	 (161)
Comment: HARDINGE CNC LATHE SMALL 1-Turn as per Folio FA633 & Dwg D3492 Dwg Rev: <u>C</u> Folio Rev: <u>B</u> <u>mv 08/10/30</u>	
3.0	QC2 INSPECT PARTS AS THEY COME OFF MACHINE
	 (161)
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>mv 08/10/30</u>	
4.0	QC8 SECOND CHECK
	 (161)
Comment: SECOND CHECK <u>mv 08/10/30</u>	
5.0	SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1
	
Comment: SMALL & MEDIUM FAB RESOURCE 1 1-Deburr if necessary <u>mv 08/10/30</u> (161) <u>km</u>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 24/10/2008 12:55:39 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PLUG

Job Number: 42936

Part Number: D3492041

Job Number:



Seq. #:

Machine Or Operation:

Description :

2-Tumble

6.0

QC5

INSPECT WORK TO CURRENT STEP



08/11/03

Comment: INSPECT WORK TO CURRENT STEP

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



161

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FL 08/11/04

8.0

POWDER COATING

POWDER COATING



M 109 152

161X

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3
(Flat End Only)

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

1:05
320 OF
1:35

M-H 08/11/04

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



40

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-11-04

161

10.0

PACKAGING 1

PACKAGING RESOURCE #1



161X

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

FP-B

M-H 08/11/04

11.0

QC21

FINAL INSPECTION/W/O RELEASE



08/11/05

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-11-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 42936
Description: Plug		Part Number: D3492-1
Inspection Dwg: D3492	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.060	+/-0.005	.060	✓			
0.060	+/-0.005	.060	✓			
Ø0.394	+/-0.010	Ø.395	✓			
Ø0.625	+/-0.010	Ø.627	✓			
0.090	+0.000/-0.002	.088	✓			
0.500	+/-0.010	.498	✓			
0.055	+0.000/-0.002	.055	✓			
0.050 x 20°	+/-0.010	.050 x 20°	✓			

Measured by: mme	Audited by: ml	Prototype Approval:	N/A
Date: 08/10/30	Date: 08/10/30	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.06.02	New Issue P/O D3492-041	KJ/JLM	
B	06.10.16	Ø0.625 was Ø0.500	KJ/JLM	
C	07.11.23	Tolerances revised	KJ/EC/DD	
D	08.06.19	0.050 x 20° dimension added	KJ/DD	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

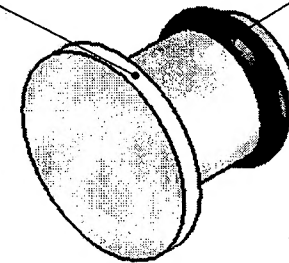
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

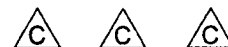
D3492-XX PLUG
(SEE TABLE)

NAS1611 PLUG
(SEE TABLE)



D3492-XXX PLUG PARTS LIST

QTY -041	QTY -043	QTY -045	QTY -047	QTY -049	QTY -051	QTY -053	PART NUMBER	DESCRIPTION
X							D3492-041	PLUG ASSEMBLY
	X						D3492-043	PLUG ASSEMBLY
		X					D3492-045	PLUG ASSEMBLY
			X				D3492-047	PLUG ASSEMBLY
				X			D3492-049	PLUG ASSEMBLY
					X		D3492-051	PLUG ASSEMBLY
						X	D3492-053	PLUG ASSEMBLY
1							D3492-1	PLUG
	1						D3492-3	PLUG
		1					D3492-5	PLUG
			1				D3492-7	PLUG
				1			D3492-9	PLUG
					1		D3492-11	PLUG
						1	D3492-13	PLUG
		1					NAS1611-005	O-RING
			1				NAS1611-007	O-RING
1							NAS1611-010	O-RING
						1	NAS1611-012	O-RING
	1						NAS1611-013	O-RING
					1		NAS1611-015	O-RING
				1			NAS1611-016	O-RING



NOTES:

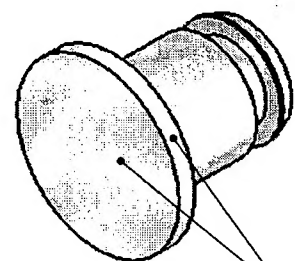
1) O-RING: POSSIBLE SUPPLIER P/N: NAS1611-XXX OR PARKER 2-XXX

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 3293

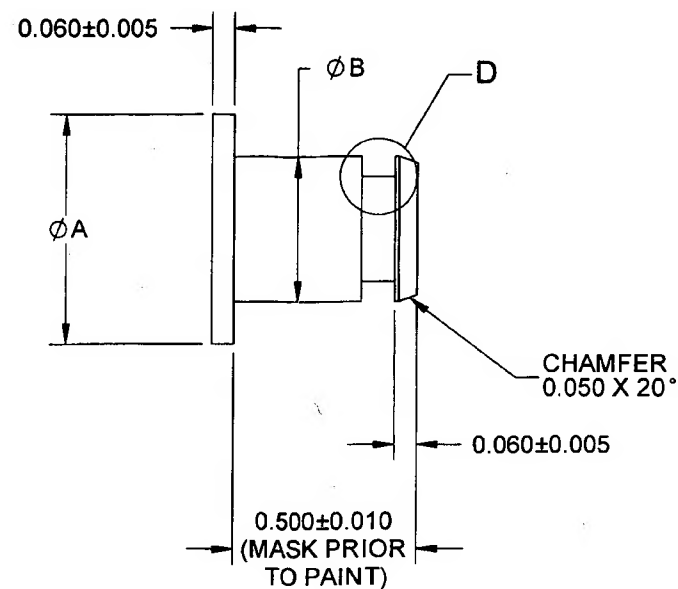
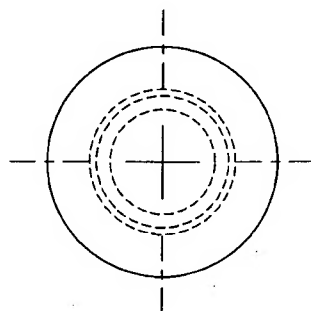
UNDER REVIEW
01.04.11 PH
DIM 4B ON D3492-13
REST OK (MAKE SMALLER)

RELEASED
07.10.05

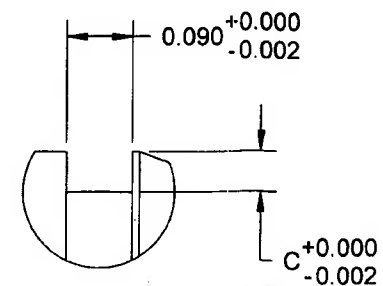
C	ADD -049/-051/-053, CHANGE DRAWING FORMAT	PH	07.10.05
B	ADD -047; UPDATE DIM A FOR -045	PH	06.05.11
A	NEW ISSUE	PH	06.01.04
REV.	DESCRIPTION	BY	DATE
DESIGN	<u>PH</u>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<u>PH</u>		
CHECKED	<u>PH</u>	DRAWING NO.	REV. C
MFG. APPR.	<u>PH</u>	D3492	SHEET 1 OF 2
APPROVED	<u>PH</u>	TITLE	SCALE
DE APPR.	<u>PH</u>	PLUG	2:1
DATE	07.10.05	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



POWDER COAT THESE
FACES ONLY PER NOTE 2



D3492-XX PLUG



DETAIL D

D3492-XX PLUG MACHINING DETAILS

P/N	A	B	C	MATERIAL SPEC
D3492-1	0.625	0.394	0.055	M6061T6R0.625
D3492-3	0.750	0.582	0.045	M6061T6R0.750
D3492-5	0.375	0.188	0.045	M6061T6R0.375
D3492-7	0.500	0.270	0.045	M6061T6R0.500
D3492-9	0.938	0.750	0.045	M6061T6R1.000
D3492-11	0.850	0.664	0.045	M6061T6R0.875
D3492-13	0.750	0.520	0.045	M6061T6R0.750

NOTES:

- 1) MATERIAL: ALUMINUM 5052-H32 OR 6061-T6 OR 1100-0 PER QQ-A-225/7 (5052) OR QQ-A-225/8 (6061) OR QQ-A-200/8 (6061) OR QQ-A-225/1 (1100) (REF. DART MATERIAL SPEC M6061T6R0.000)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

SHOP COPY
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ENGINEERING
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 42936

UNDER REVIEW
01.04.21
DIM ØB ON D3492-13
REST OK (MAKE SMALLER)

RELEASED
07.11.16

DESIGN	Rev	DART AEROSPACE LTD	
DRAWN	Rev	HAWKESBURY, ONTARIO, CANADA	
CHECKED	Rev	DRAWING NO.	REV. C
MFG. APPR.	Rev	D3492	SHEET 2 OF 2
APPROVED	Rev	TITLE	SCALE
DE APPR.	Rev	PLUG	4:1
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